<u>What is claimed is:</u>

1. A method of producing low-dust granules of polymer additives or polymer additive
    mixtures, wherein the granule-forming polymer additives are mixed together, the mixture
    is converted into a workable mass and pressed through an orifice, and the pre-shaped
    strand-like extruded mass is cooled and, while still in a workable state, formed into
    granules by rolling, impressing, cooling and comminuting.

2. A method according to claim 1, wherein there are mixed together as granule-forming
    polymer additives phenolic polymer additives of formula:
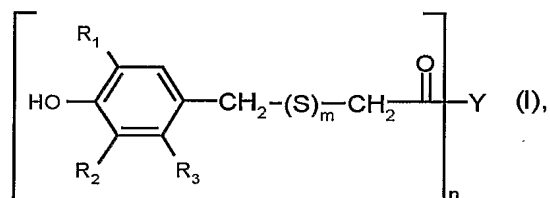
    wherein, independently of one another, one of R_1 and R_2 is hydrogen, a substituent
    selected from the group C_1-C_{18}alkyl, phenyl, $(C_1$-C_4alkyl$)_{1-3}$phenyl, phenyl-C_1-C_3alkyl,
    $(C_1$-C_4alkyl$)_{1-3}$phenyl-C_1-C_3alkyl, C_5-C_{12}cycloalkyl and $(C_1$-C_4alkyl$)_{1-3}C_5$-C_{12}cycloalkyl or a
    group of partial formula
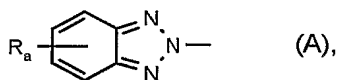
    wherein R_a is hydrogen or a substituent selected from the group C_1-C_4alkyl, halogen
    and sulfo;

    and the other is a substituent selected from the group C_1-C_{18}alkyl, phenyl,
    $(C_1$-C_4alkyl$)_{1-3}$phenyl, phenyl-C_1-C_3alkyl, $(C_1$-C_4alkyl$)_{1-3}$phenyl-C_1-C_3alkyl,
    C_5-C_{12}cycloalkyl and $(C_1$-C_4alkyl$)_{1-3}C_5$-C_{12}cycloalkyl or a group of partial formula (A)
    wherein R_a is as defined;

    R_3 is hydrogen or methyl;

    m is the number zero or 1; and

    n is an integer from 1 to 4; wherein,

    when n is the number 1,

    m is zero or 1 and Y denotes

a monovalent substituent $-O-Y_1$ or $-N(-Y_2)_2$, wherein

Y_1 is C_5-C_{45}alkyl, C_3-C_{45}alkyl interrupted by at least one oxygen atom, C_5-C_{12}cycloalkyl, C_2-C_{12}alkenyl,
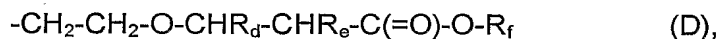
a substituent of partial formula

$$-CH_2-CH(OH)-CH_2-O-C(=O)-R_b, \qquad (B),$$

wherein R_b is hydrogen, C_1-C_8alkyl, C_3-C_5alkenyl or benzyl,

a substituent of partial formula

$$-CH_2-CH_2-O-R_c \qquad (C),$$

wherein R_c is hydrogen, C_1-C_{24}alkyl, C_5-C_{12}cycloalkyl or phenyl,

a substituent of partial formula

$$-CH_2-CH_2-O-CHR_d-CHR_e-C(=O)-O-R_f \qquad (D),$$
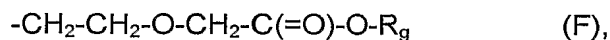
wherein one of R_d and R_e is hydrogen or methyl and the other is methyl, and R_f is hydrogen or C_1-C_{24}alkyl,

a substituent of partial formula
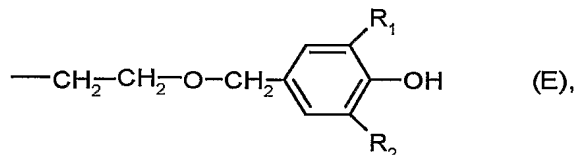
wherein R_1 and R_2 are as defined above,

or a substituent of partial formula

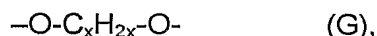$$-CH_2-CH_2-O-CH_2-C(=O)-O-R_g \qquad (F),$$

wherein R_g is hydrogen or C_1-C_{24}alkyl; and

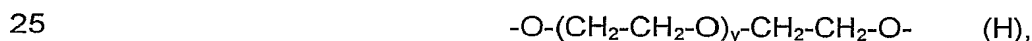Y_2 is hydroxy-C_2-C_4alkyl; or,

when n is the number 2,
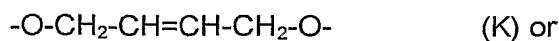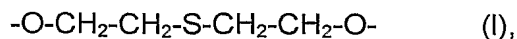
m is zero and Y is a bivalent group of partial formula

$$-O-C_xH_{2x}-O- \qquad (G),$$

wherein x is an integer from 2 to 20,

$$-O-(CH_2-CH_2-O)_y-CH_2-CH_2-O- \qquad (H),$$

wherein y is an integer from 1 to 30,

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$$-O-CH_2-CH_2-S-CH_2-CH_2-O- \qquad (I),$$

$$-O-CH_2-CH=CH-CH_2-O- \qquad (K) \text{ or}$$

$$-NH-(CH_2)_z-NH- \qquad (L),$$
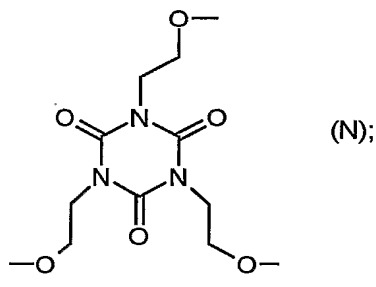
wherein z is zero or an integer from two to ten; or,

when n is the number 3, m is zero and Y is a trivalent group of partial formula

$$\begin{array}{c} -O-CH_2 \\ -O-CH_2-\!\!\!\!\!\!\!\!\!\!\!\!\!\!-R_h \\ -O-CH_2 \end{array} \qquad (M),$$
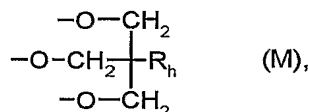
wherein R_h is C_1-C_{24}alkyl or phenyl, or

(N);

when n is the number 4, m is zero and Y is the tetravalent group of partial formula

$$\begin{array}{c} -O-CH_2 \\ -O-CH_2-\!\!\!\!\!\!\!\!\!\!\!\!\!\!-CH_2-O- \\ -O-CH_2 \end{array} \quad .$$
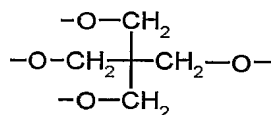
3. A method according to claim 1, wherein there are mixed together as granule-forming polymer additives phenolic polymer additives of formula:
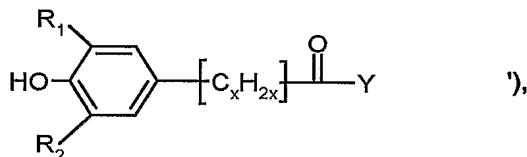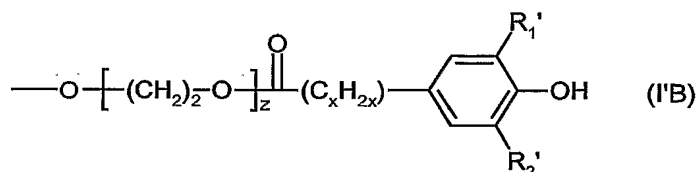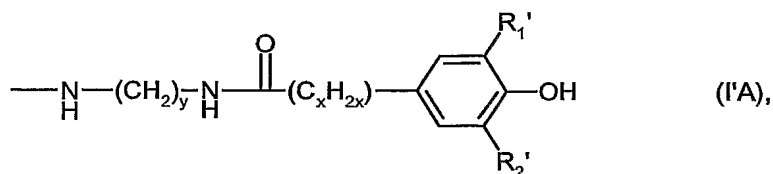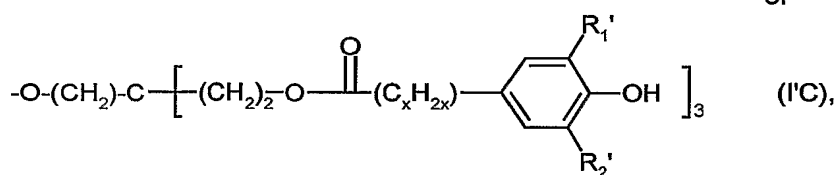

'),

wherein, independently of one another, one of R_1 and R_2 is hydrogen or C_1-C_4alkyl and the other is C_3-C_4alkyl; x is zero (direct bond) or an integer from one to three; and Y is C_8-C_{22}alkoxy or a group of partial formula

$$\text{—N—}(CH_2)_y\text{—N—}\overset{O}{\overset{\|}{C}}\text{—}(C_xH_{2x})\text{—}\underset{R_2'}{\overset{R_1'}{\bigcirc}}\text{—OH} \qquad (I'A),$$

$$\text{—O—}[(CH_2)_2\text{—O—}]_z\overset{O}{\overset{\|}{C}}\text{—}(C_xH_{2x})\text{—}\underset{R_2'}{\overset{R_1'}{\bigcirc}}\text{—OH} \qquad (I'B)$$

or

$$\text{-O-}(CH_2)\text{-C-}[(CH_2)_2\text{-O—}\overset{O}{\overset{\|}{C}}\text{—}(C_xH_{2x})\text{—}\underset{R_2'}{\overset{R_1'}{\bigcirc}}\text{—OH}]_3 \qquad (I'C),$$

wherein, independently of one another, one of R_1' and R_2' is hydrogen or C_1-C_4alkyl and the other is C_3-C_4alkyl; x is zero (direct bond) or an integer from one to three; y is an integer from two to ten and z is an integer from two to six.

4. A method according to claim 1, wherein the mixture of granule-forming polymer additives is converted into a workable mass in a heatable ko-kneader.

5. A method according to claim 1, wherein the workable mass is extruded from the ko-kneader through a circular nozzle or slot-shaped nozzle and the pre-shaped, strand-like mass is subjected to further processing.

6. A method according to claim 1, wherein the plastic, pre-shaped mass is processed by squeeze rollers having a smooth and polished surface and then shaping rollers provided with embossing lines.

7. A method according to claim 1, wherein the shaping rollers are provided with grooves.

8. A method according to claim 1, wherein the transport and the cooling and solidification are carried out on a continuous steel belt.

9. A method according to claim 1, wherein the components of the granule-forming polymer additives are fed into the ko-kneader in liquid or solid form or in molten form.

10. A method according to claim 1, wherein the impressed product mat is comminuted to granule size in a sieve granulator.